

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003632**Date Inspected:** 17-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang / Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** skin plates and stiffeners / deck panels**Summary of Items Observed:****Tower Shop – Bay 1**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed ZPMC personnel performing the following: grinding preparation for root pass of SAW butt weld at SSD1-SA179; FCAW-G of stiffeners to skin plates to SSD1-E and SSD1-A; grinding of stiffener butt welds. Approximately 50 workers were present in this shop including ZPMC CWI An Qing Xiang and ABF QC Jiang Zi Wen.

Tower Shop – Bay 2

QA Inspector randomly observed ZPMC personnel performing the following: SAW stiffener butt welding and SAW skin plate butt welding to WSD1-SA39A/K-15A. ABF QC Zhang Ji Cai was present as well as approximately 50 ZPMC workers.

Heavy Duty Machine Shop – Bay 3

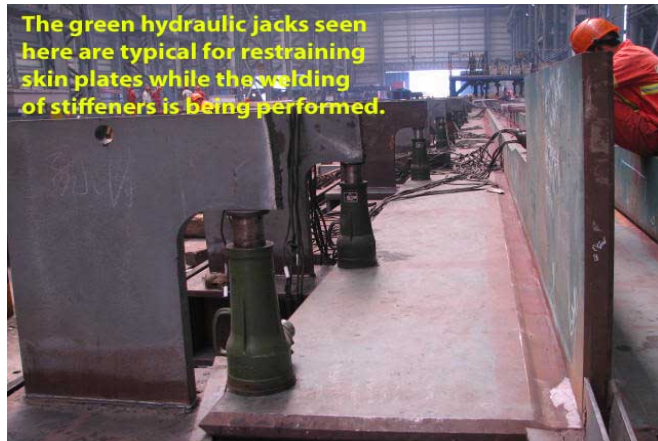
QA Inspector randomly observed ZPMC personnel performing the following: grinding on the following deck panels: DP549-001 and DP549-002 as well as wire wheel cleaning of welds on DP554-001; UT shear wave and thickness readings of DP244-001.

ZPMC CWI Sun Wei and ABF QC Kevin Chen were present in this bay.

ZPMC CWI Sun Wei arrived 20 minutes late for 1330 hours scheduled final VT inspections.

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Summary of Conversations:

ZPMC QC Fu Yuhong informed QA Inspector that final VT inspections would begin at 1330 hours in Bay 3. At 1340 hours QA Inspector asked the ABF QC, noted above, where the ZPMC CWI was. The ABF QC replied that he did not know and that he had not seen the ZPMC CWI.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George
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Quality Assurance Inspector

Reviewed By:	Carreon, Albert
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QA Reviewer
